

Work Order ID 51807

Thursday, September 03, 2009 11:44:51 AM



Page 1

Item ID: D350-636-012

Accept



Setup Start



Revision ID: F

Stop



Item Name: Skidtube RH

Start Date: 9/3/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 9/15/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

RP mlt

Date:

09-9-03

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2750

Rev F

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-012 CHG 004

Sos 10/05

HJ for BG 09/10/05

51807

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Cust Item ID:

Required Date: 9/15/2009 Req'd Qty: 1.00



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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

110



Skidtubes

Skidtubes

0.00

0.00

Memo

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 5 (D2750-2 details).Drill using drill Jig DT8150 & DT8863 .

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750.

4-Drill pilot holes for blade fitting bolts using DT8983. Open to 0.500"

5- locate DT8329 off of blade fitting bolt holes and drill pilot holes blade fitting.

6-Open up holes for Detail K to 0.375" (4 holes per side) blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open holes for ground handling and detail L to 0.500" (8 holes per side)

7-Drill pilot holes for wearplates as per Dwg.D2750 using DT8108. Open to 0.297".

8-Open up holes of Detail J to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004

A/R□□□ Aluminum Rod

□ 1111682

10-Grind welds flush as per Dwg D2750

BE 09/09/10

BE 09/09/10

AWM 9-9-14

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Start Date: 9/3/2009 Start Qty: 1.00



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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

11- scribe batch #.

120

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

27 S 08/09/14



0

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

27 S 08/09/14



0

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

1 0 - AWM 9-9-25

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Required Date: 9/15/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 *AD* *BF* 09/09/15

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Required Date: 9/15/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

160



Skidtubes

0.00

Skidtubes

Memo

0.00

Skidtubes

1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.

3-Open float holes to .500" (4 per Side)

4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)

5-Deburr and blow out all chips from inside of tube

6-Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R ☐☐☐ Sikaflex-291

batch: ☐☐☐

exp. date: 10-2-20

M112391

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9)

A/R ☐☐☐ Aluminum Rod

batch: M11682

BE 09-09-16

9-Grind welds flush as per Dwg D2750

G.M 09-09-28 ①

10-Spot face ground handling holes section (total of 4 places per side) as per dwg D2750

A.M 09-09-20 ①

1 ~~0~~ - Ann 7-7-15

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

11-Deburr holes 0.11 09-09-2009

170

QC10- Inspect visual per QSI004- ground welds 5 0.00

2) 8/10/08



QC

Memo

0.00

Quality Control



180

QC5- Inspect part completeness to step on W/O 0.00

2) 8/10/08



QC

Memo

0.00

Quality Control



190

Pressure Wash per QSI005 4.3 0.00

2) 8/10/08

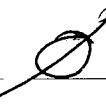


HandFinish

Memo

0.00

Hand Finishing



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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo 1112260 START TIME: 3:30pm OVEN TEMPERATURE: 320°F FINISH TIME: 4:06pm	0.00 0.00	27	09/09/29		X1	0		
210 QC Quality Control	QC3- Inspect Part Finish Memo Inspect for foreign object per QSI 024	0.00 0.00	27	09/09/30		X1	0		
220 HandFinish Hand Finishing	HandFinishing Memo Install inserts as per dwg D2750	0.00 0.00	MD	09/09/30		X1			

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Cust Item ID:

Required Date: 9/15/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	HandFinishing	0.00							
	HandFinish								
Hand Finishing	Memo	0.00				X/			
	1-Inspect for Foreign Objects								
	2-Spray inside of tube with "LPS-3" batch: <u>2/0</u>								
	3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: <u>m112100</u> EXP DATE: <u>10/20</u>								
	4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: <u>m101223</u>								
	5-Coat all exposed fasteners with "LPS Procyon" batch: <u>m104251</u>								
240	QC5- Inspect part completeness to step on W/O	0.00							
	QC								
Quality Control	Memo	0.00							

MD 09/09/30

2801/10/02

(X)

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Setup Start



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Item Name: Skidtube RH

Start Date: 9/3/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 9/15/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250 Packaging	Pick Kit	0.00							
Packaging	Memo	0.00				9/10/5		WSP	
260 QC	QC4- 100% Inspect kits for completeness	0.00							
Quality Control	Memo	0.00		27509/10/05		Ⓢ			
270 Packaging	Packaging	0.00							
Packaging	Memo Package as per PPP D350-636-012	0.00		Rev 5		9/10/5		WSP	

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Revision ID: F

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Item Name: Skidtube RH

Start Date: 9/3/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 9/15/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/06

U 09-10-05

Picklist Print

Thursday, September 03, 2009 11:44:58 AM

Page 1

Work Order ID: 51807



Parent Item: D350-636-012RevF



Parent Item Name: Skidtube RH

Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ALS4-1032-225		Purchased	No			220	Each	8,785.000	38.0000			

Insert

Warehouse
Location
Main Warehouse
ST

Loc Qty

Loc Code

8785

107441

16

110768

8769

X38 MD 09/09/30

AN3C5A

Purchased

No



230

Each

646.0000

34.0000



Bolt

Warehouse
Location
Main Warehouse
ST

Loc Qty

Loc Code

646

111424

8

111707

338

112314

200

112489

100

X34 MD 09/09/30

AN3C6A

Purchased

No



230

Each

1,048.000

4.0000



BOLT

Warehouse
Location
Main Warehouse
ST

Loc Qty

Loc Code

1048

110372

72

111982

976

X4 MD 09/09/30

Picklist Print

Page 2

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Work Order ID: 51807



Parent Item: D350-636-012RevF



Parent Item Name: Skidtube RH

Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN6C44A 		Purchased	No			230	Each	172.0000	4.0000			
BOLT												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	2	
103964	2	
Main Warehouse		
ST	170	
110105	4	
110155	14	
110665	1	
110865	51	
111605	50	
111649	50	

X 4 MD 09/09/30

AN8C35A 	Purchased	No				230	Each	167.0000	1.0000			
BOLT												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	167	
102180	1	
106896	1	
110105	65	
110847	100	

X 1 MD 09/09/30

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Parent Item: D350-636-012RevF



Parent Item Name: Skidtube RH


Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C10L  washer		Purchased	No			230	Each	2,450.000	38.0000			

Warehouse Location	Loc Qty	Loc Code
OFFSHORE	112612	

X38 MD 09/09/30

FG	100	
103585	100	
Main Warehouse		
FP	-44	
112116	-44	
Main Warehouse		
ST	2394	
112116	2394	

AN960C816L

Purchased

No

230

Each

330.0000

1.0000



WASHER

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		

ST	330	
104093	2	
107520	4	
110139	29	
110372	36	
110584	100	
111424	159	

X1 MD 09/09/30

Picklist Print

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Parent Item: D350-636-012RevF



Parent Item Name: Skidtube RH


Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2745RevB 		Manufactured	No			230	Each	272.0000	8.0000			
X Bushing												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	272
34817	2
36230	8
37303	1
39587	2
40726	2
41114	2
42778	19
43754	2
44893	37
45556	69
46695	18
48278	110

14
MD 09/09/30
14

D3488-042RevB

Manufactured No



~~X~~ Blade Fitting Assembly, RH

230 Each 9.0000 1.0000



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	9
29043	1
44531	8

21
MD 09/09/30

Picklist Print

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Parent Item: D350-636-012RevF



Parent Item Name: Skidtube RH

Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3492-041RevC		Manufactured	No			230	Each	3.0000	8.0000			

Plug Assembly

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

43816

3

3

Each

0.0000

8.0000

51584

x8 MD 09/09/30

D3492-043RevC

Manufactured

No

Plug Assembly

D3535-25RevB

Manufactured

No

Wearshoe

230

51642



x8 MD 09/09/30

230

Each

11.0000

1.0000

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

11

47523

11

x1 MD 09/09/30

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Parent Item: D350-636-012RevF



Parent Item Name: Skidtube RH

Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3536-25RevA		Manufactured	No			230	Each	21.0000	1.0000			



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 21

45569 1

47011 2

47526 8

50266 10

X1 MD 09/09/30

D3537-1RevC

Manufactured No

230

Each

46.0000

3.0000



Wearpad

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP 46

48288 3

50321 43

X3 MD 09/09/30

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Parent Item: D350-636-012RevF



Parent Item Name: Skidtube RH



Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3631-1RevA 		Manufactured	No			230	Each	105.0000	8.0000			
Washer												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

105

38139

6

45353

16

47437

83

D3791-1RevA

Manufactured No



230

Each

18.0000

1.0000

Wearplate



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

18

47536

8

50269

10

X8 MD 09/09/30

XI MD 09/09/30

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Parent Item Name: Skidtube RH


Comments:

Start Date: 9/3/2009

Required Date: 9/15/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3793-1RevA  Wearshoe		Manufactured	No			230	Each	18.0000	1.0000			

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

18

40551

1

47537

4

50231

13

230

Each

22.0000

1.0000

XI md 09/09/30

D3793-3RevA



Wearshoe

Manufactured

No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

22

47720

11

50216

11

XI md 09/09/30

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Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3794-1RevA Manufactured No

230

Each

7.0000

1.0000



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

46530

47212

47721

51668

7

1

2

4

230

Each

27.0000

1.0000

D3794-3RevA

Manufactured No



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

46531

47440

47722

50240

27

2

2

11

12

X1 MD 09/09/30

X1 MD 09/09/30

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Required Date: 9/15/2009

Comments:

Start Qty: 1.00

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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MS21043-6		Purchased	No			230	Each	1,132.000	4.0000			
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Warehouse	Location	Loc Qty	Loc Code
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Main Warehouse

ST	1132	
----	------	--

110584	34	
--------	----	--

111424	98	
--------	----	--

112314	1000	
--------	------	--

X3
X1 MD 09/09/30

MS21083C8		Purchased	No			230	Each	92.0000	1.0000			
-----------	--	-----------	----	--	--	-----	------	---------	--------	--	--	--



Warehouse	Location	Loc Qty	Loc Code
-----------	----------	---------	----------

Main Warehouse

ST	92	
----	----	--

110584	5	
--------	---	--

111424	2	
--------	---	--

111637	21	
--------	----	--

112243	44	
--------	----	--

112492	20	
--------	----	--

X1 MD 09/09/30

Thursday, September 03, 2009 11:44:59 AM

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Thursday, September 03, 2009 11:44:59 AM

Work Order ID: 51807



Parent Item: D350-636-012RevF



Parent Item Name: Skidtube RH

Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

NAS1611-010

Purchased

No

230

Each

345.0000

8.0000



O-RING

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

345

110715

50

110915

295

NAS1611-013

Purchased

No

230

Each

320.0000

8.0000



O-RING

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

320

106513

11

111424

109

111758

200

740

X8 mo 09/09/30

Thursday, September 03, 2009 11:44:59 AM

Shop Packet Print

Page 11

W/O: 51807		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09/09/30		changed O-ring WAS 1611-010 By O-ring D2594-3 Batch 8 <u>BS1613</u> x 8	MD	09/09/30	8		09/09/30 S

Part No: D350-636-012 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, September 03, 2009 11:44:59 AM

Work Order ID: 51807

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH



Comments:

Start Date: 9/3/2009

Required Date: 9/15/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN8C21A		Purchased	No			260	Each	112.0000	2.0000			
												
BOLT												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	112
105160	1
107596	1
107924	2
109092	2
110341	2
110342	4
111605	50
111684	50

2 9/10/5 SP

AN960C816L

Purchased

No

260

Each

330.0000

2.0000



WASHER



Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	330
104093	2
107520	4
110139	29
110372	36
110584	100
111424	159

2 9/10/5 @ SV

Picklist Print

Page 13

Thursday, September 03, 2009 11:44:59 AM

Work Order ID: 51807



Parent Item: D350-636-012RevF



Parent Item Name: Skidtube RH

Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2741RevC		Manufactured	No			260	Each	40.0000	1.0000			
Blade, 350 Skidtube												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 40

20770 0

45320 1

47113 39

D3493-1RevA		Manufactured	No			260	Each	115.0000	2.0000			
Washer												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 115

44902 15

47710 100

D3532-1RevA		Manufactured	No			260	Each	43.0000	2.0000			
Spacer												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 43

38161 2

44904 41

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Page 13

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Page 14

Thursday, September 03, 2009 11:44:59 AM

Work Order ID: 51807

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH



Comments:

Start Date: 9/3/2009

Required Date: 9/15/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21083C8		Purchased	No			260	Each	92.0000	2.0000			
												
NUT												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	92	
110584	5	
111424	2	
111637	21	
112243	44	
112492	20	

2 9/10/09 50

NAS1515H3L

Purchased

No

260

Each

350.0000

4.0000



WASHER

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	40	
102472	40	
Main Warehouse		
ST	310	
110450	2	
110806	8	
111819	300	

29 MD 09/09/30

Thursday, September 03, 2009 11:44:59 AM

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W/O: 57807		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09/09/30		Rate Seq ID for NAS 155 H3L should be 230 instead of 260	MD	09/09/30	4		1/1/3

Part No: D 350-636-012 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: 57807		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 15

Thursday, September 03, 2009 11:44:59 AM

Work Order ID: 51807

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH


Comments:

Start Date: 9/3/2009

Required Date: 9/15/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
8 NAS1515H8L  WASHER		Purchased	No			260	Each	129.0000	2.0000		9/10/5 50	

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

129

107581

34

108964

1

111650

94

D2600-3-BENTRevD1

Manufactured

No



Extrusion Bent

D2744RevC

Manufactured

No



Cap

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

50

44892

15

47488

35

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Page 15

Picklist Print

Page 16

Thursday, September 03, 2009 11:44:59 AM

Work Order ID: 51807

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH

Comments:

Start Date: 9/3/2009

Required Date: 9/15/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2739RevD

Manufactured

No

160

Each

6.0000

1.0000



350 I Beam

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

4

50353

4

Main Warehouse

ST

2

47124

1

47681

1

B-51919 - AWM 9-9-15

D2743RevB

Manufactured

No

160

Each

294.0000

8.0000



Crossbolt Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

50

50281

50

Main Warehouse

ST

244

44891

2

45555

177

48275

65

A 8 DE 9-9-16

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Shop Packet Print

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Page 17

Thursday, September 03, 2009 11:44:59 AM

Work Order ID: 51807

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH


Comments:

Start Date: 9/3/2009

Required Date: 9/15/2009

Start Qty: 1.00


Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3490-3RevA		Manufactured	No			160	Each	112.0000	4.0000			
												
Cross Bolt Spacer												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	112	
45560	22	
47471	35	
48276	55	


 4 BE 9-9-16

D3490-1RevA		Manufactured	No			160	Each	165.0000	4.0000			
												
Cross Bolt Spacer												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	165	
45338	2	
47118	4	
47657	50	
48277	109	

 4 BE 9-9-16

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W/05/807

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-5	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

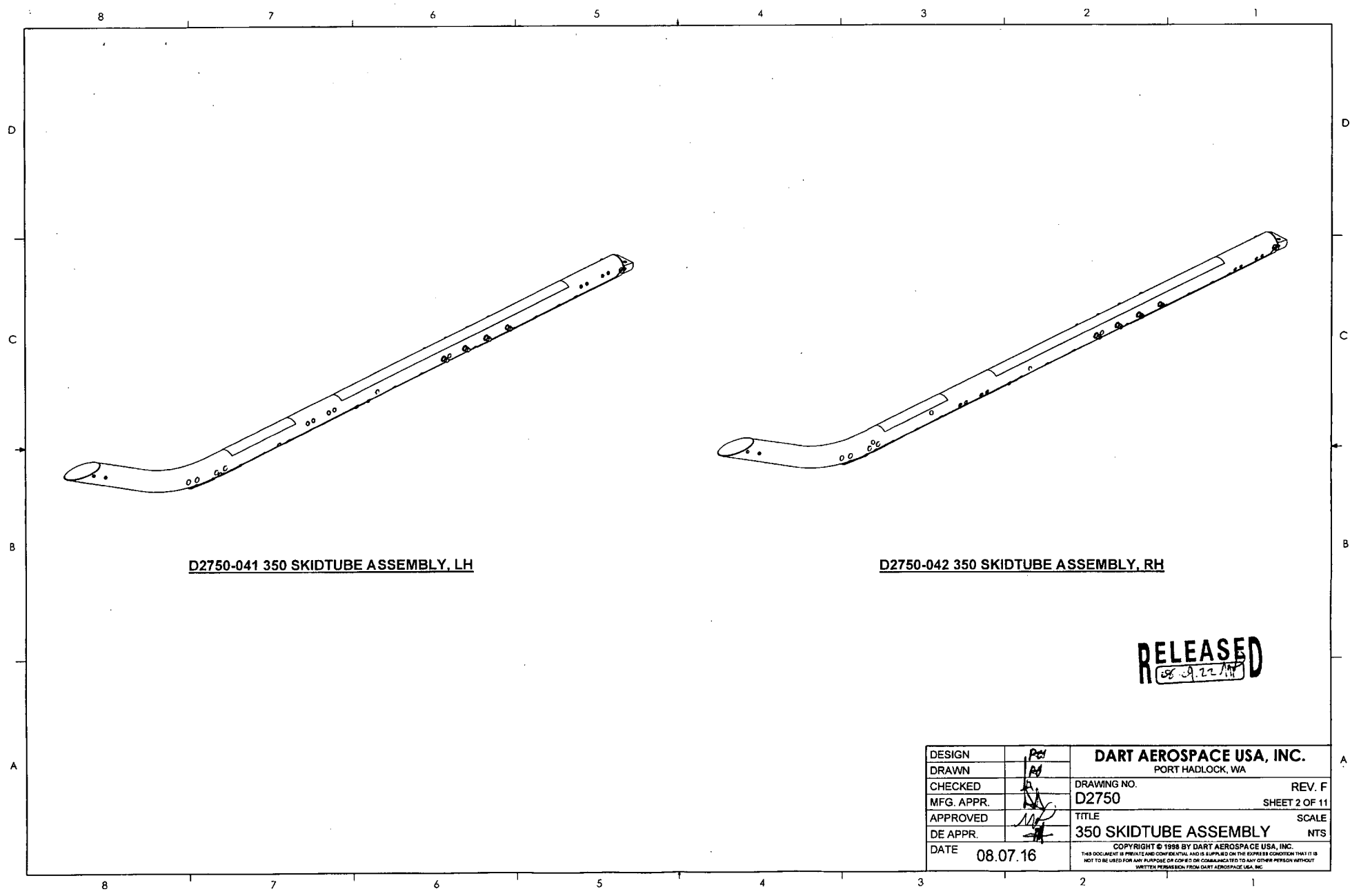
GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

RELEASED
6-27-77

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL); WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS, ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515HBL; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEC 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-15A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PA	DART AEROSPACE USA, INC.	
DRAWN	REH	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 1 OF 11
DE APPR.		TITLE	SCALE
DATE	08.07.16	350 SKIDTUBE ASSEMBLY	NTS
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W/O 5/807



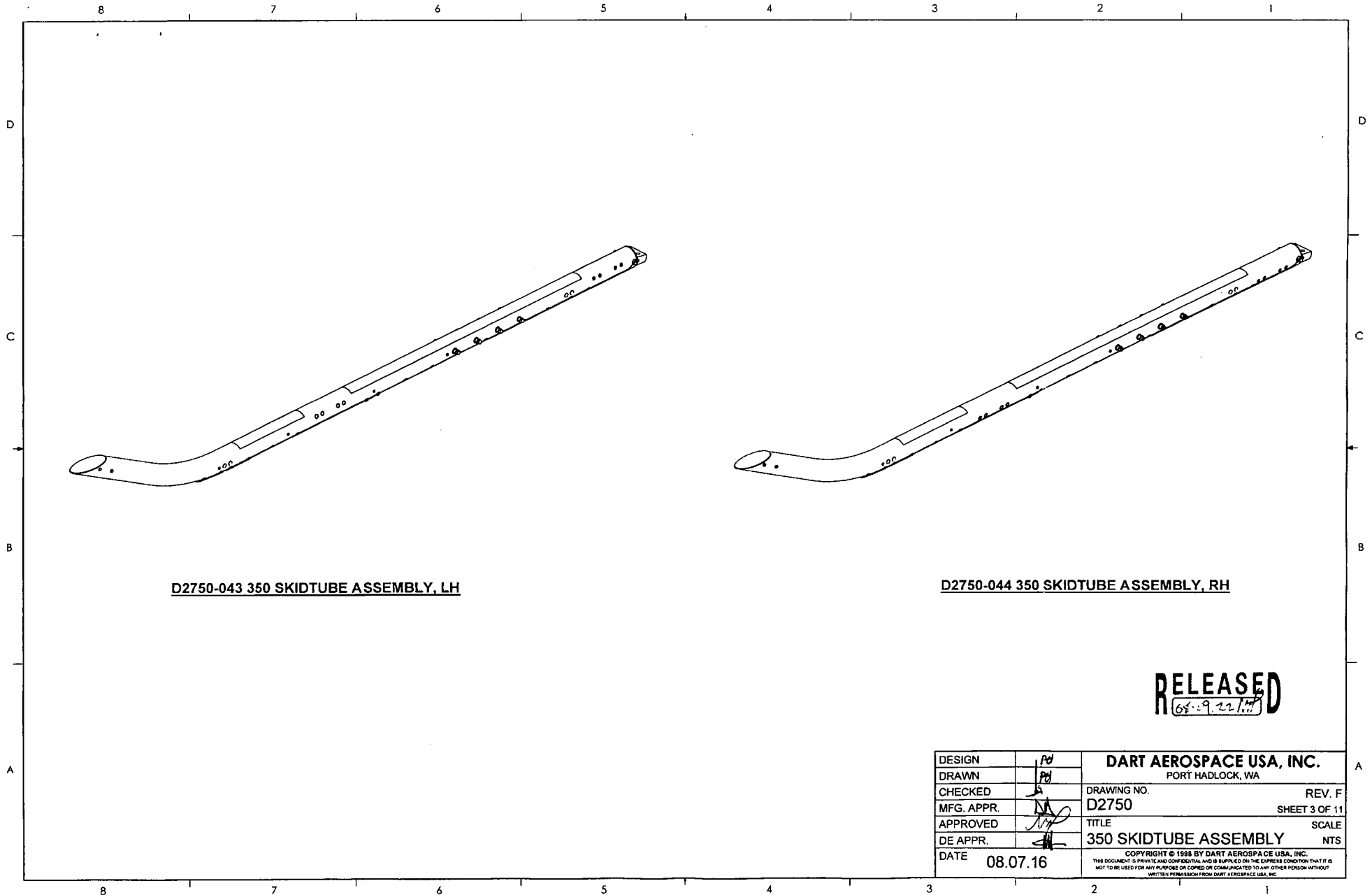
D2750-041 350 SKIDTUBE ASSEMBLY, LH

D2750-042 350 SKIDTUBE ASSEMBLY, RH

RELEASED
18 JUL 1971

DESIGN	PM	DART AEROSPACE USA, INC.	
DRAWN	AM	PORT HADLOCK, WA	
CHECKED	SA	DRAWING NO.	REV. F
MFG. APPR.	MA	D2750	SHEET 2 OF 11
APPROVED	MA	TITLE	SCALE
DE APPR.	MA	350 SKIDTUBE ASSEMBLY	NTS
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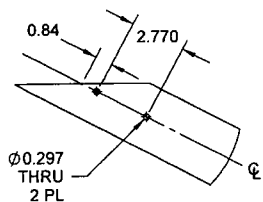
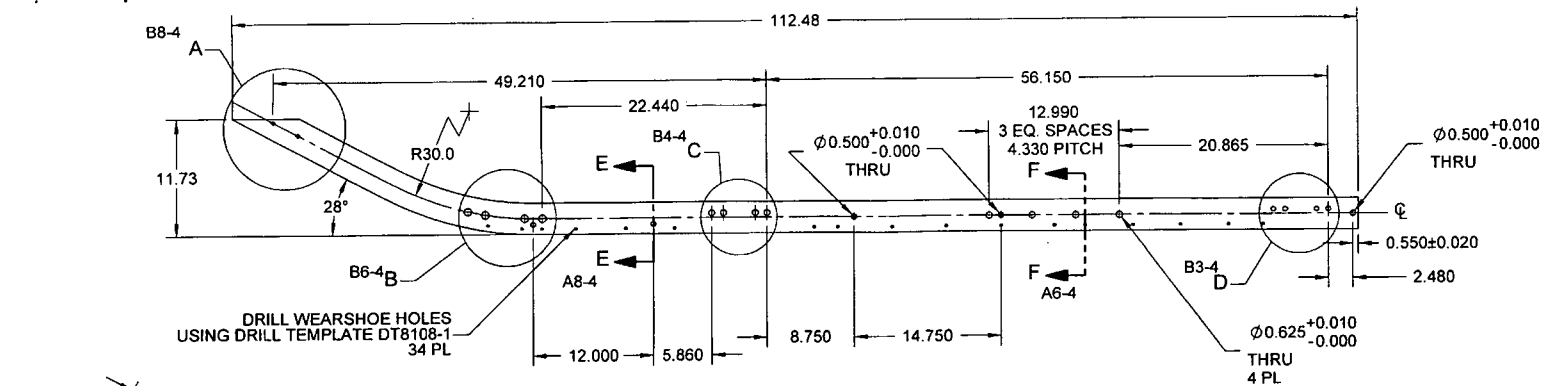


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68-9-22/100

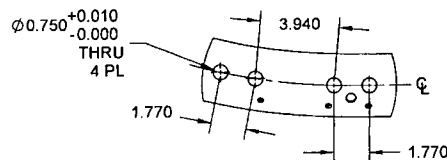
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DRAWN	PD	PORT HADLOCK, WA	
CHECKED	NA	DRAWING NO.	REV. F
MFG. APPR.	NA	D2750	SHEET 3 OF 11
APPROVED	NA	TITLE	SCALE
DE APPR.	NA	350 SKIDTUBE ASSEMBLY	NTS
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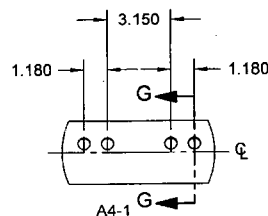
D2750-1 LH SKIDTUBE



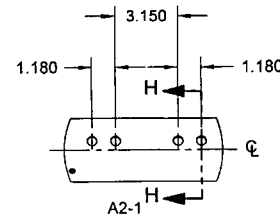
DETAIL A
SCALE 2X



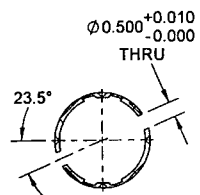
DETAIL B
SCALE 2X



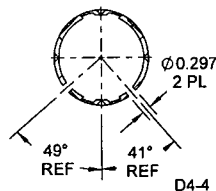
DETAIL C
SCALE 2X



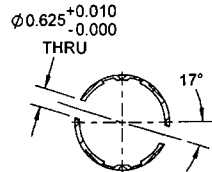
DETAIL D
SCALE 2X



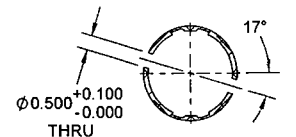
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL

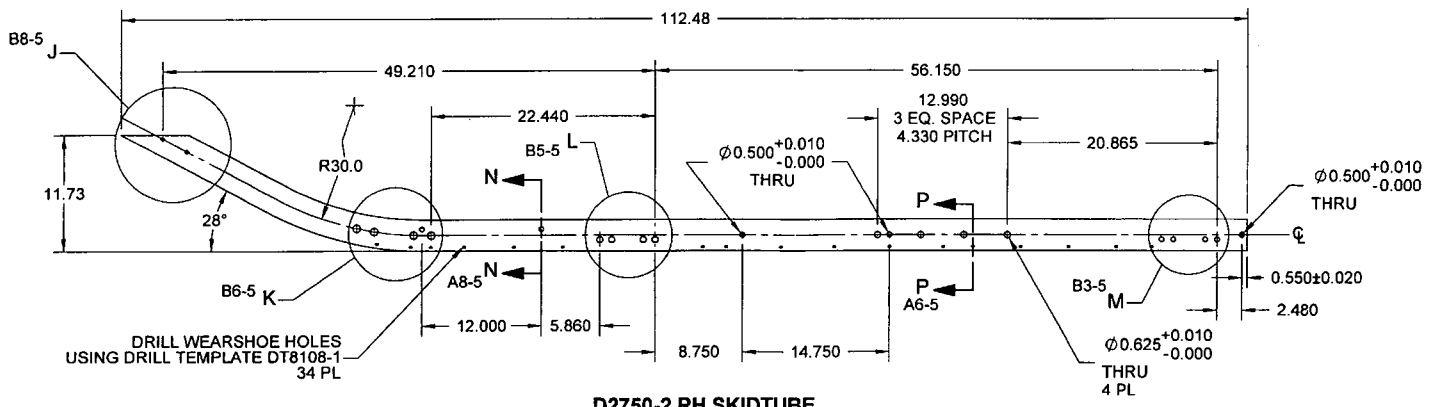


SECTION H-H
SCALE 3X, 4 PL

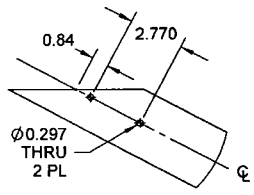
RELEASED

DESIGN	PM	DART AEROSPACE USA, INC.	
DRAWN	PM	PORT HADLOCK, WA	
CHECKED	PM	DRAWING NO. D2750	REV. F
MFG. APPR.		SHEET 4 OF 11	
APPROVED		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS
DE APPR.		COPYRIGHT © 1988 BY DART AEROSPACE USA, INC.	
DATE 08.07.16		THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

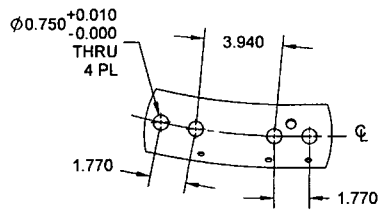
W/O 51807



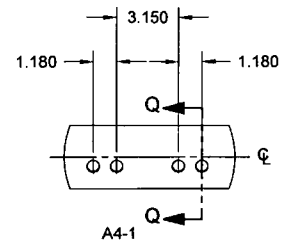
D2750-2 RH SKIDTUBE



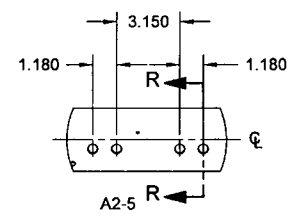
DETAIL J
SCALE 2X



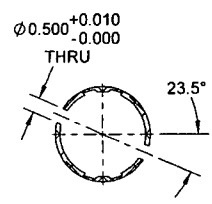
DETAIL K
SCALE 2X



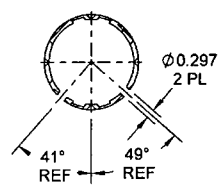
DETAIL L
SCALE 2X



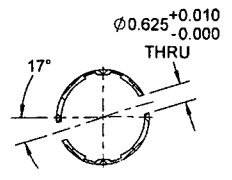
DETAIL M
SCALE 2X



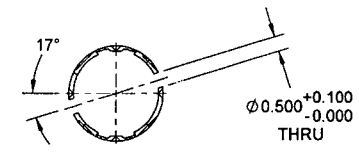
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL

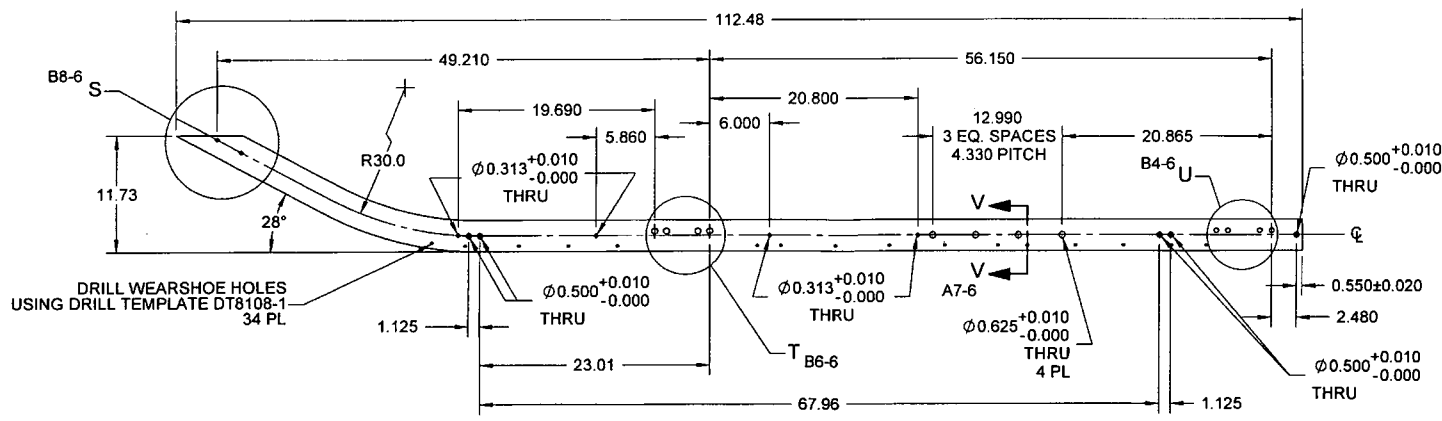


SECTION R-R
SCALE 3X, 4 PL

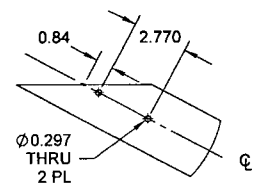
RELEASED

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DRAWN	W/	PORT HADLOCK, WA	
CHECKED		DRAWING NO. D2750	REV: F
MFG. APPR.			SHEET 5 OF 11
APPROVED		TITLE 350 SKIDTUBE ASSEMBLY	SCALE
DE APPR.			NTS
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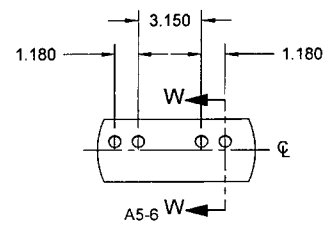
W/A 51807



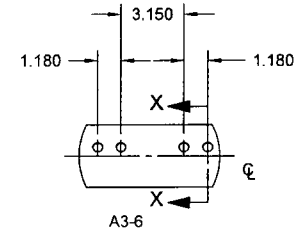
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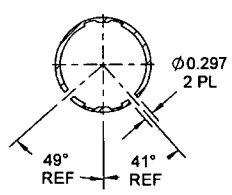
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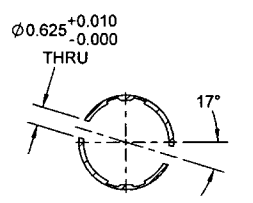
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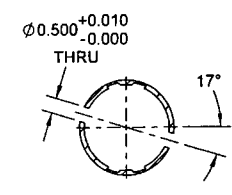
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SECTION V-V
SCALE 3X, 17 PL



SECTION W-W
SCALE 3X, 4 PL

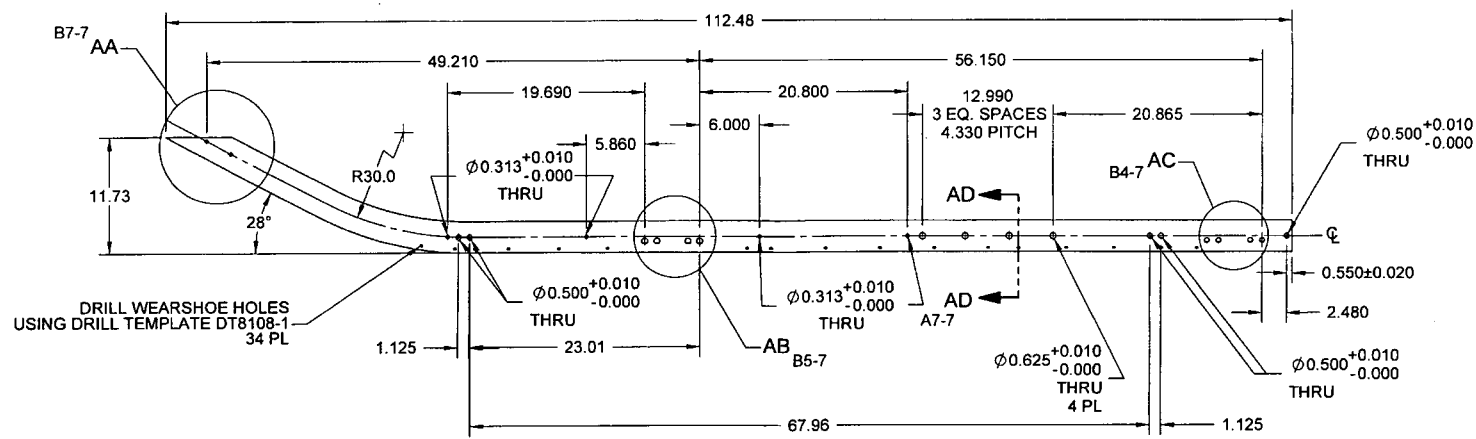


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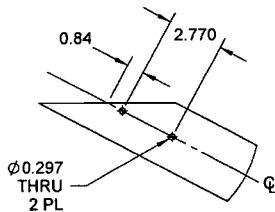
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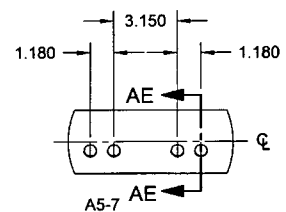
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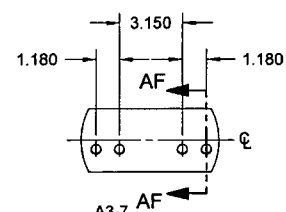
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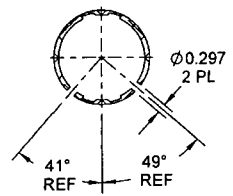
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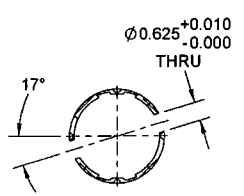
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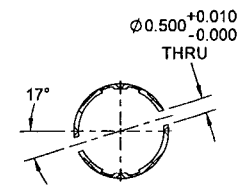
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SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL

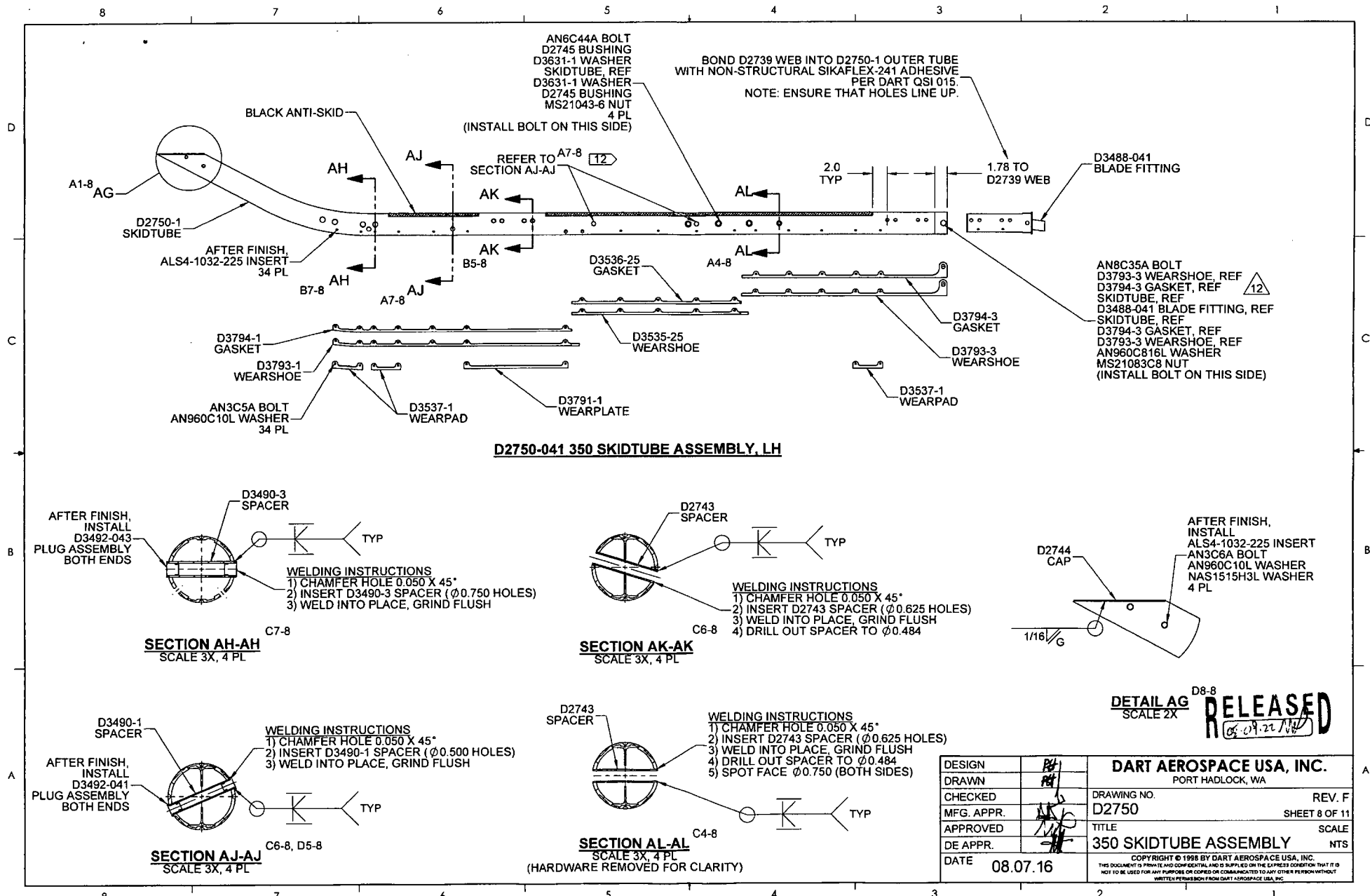


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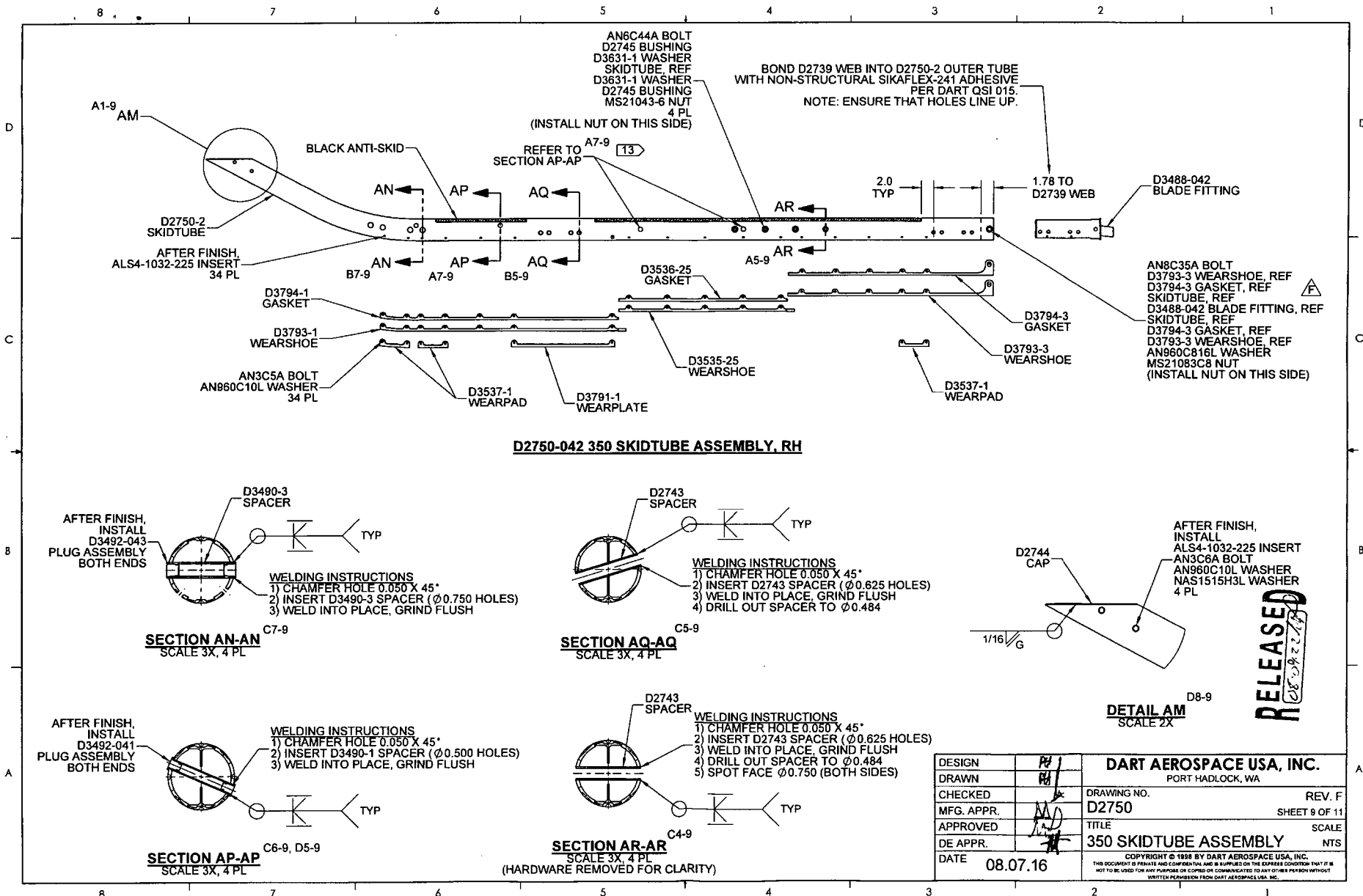
RELEASED
08-04-2017

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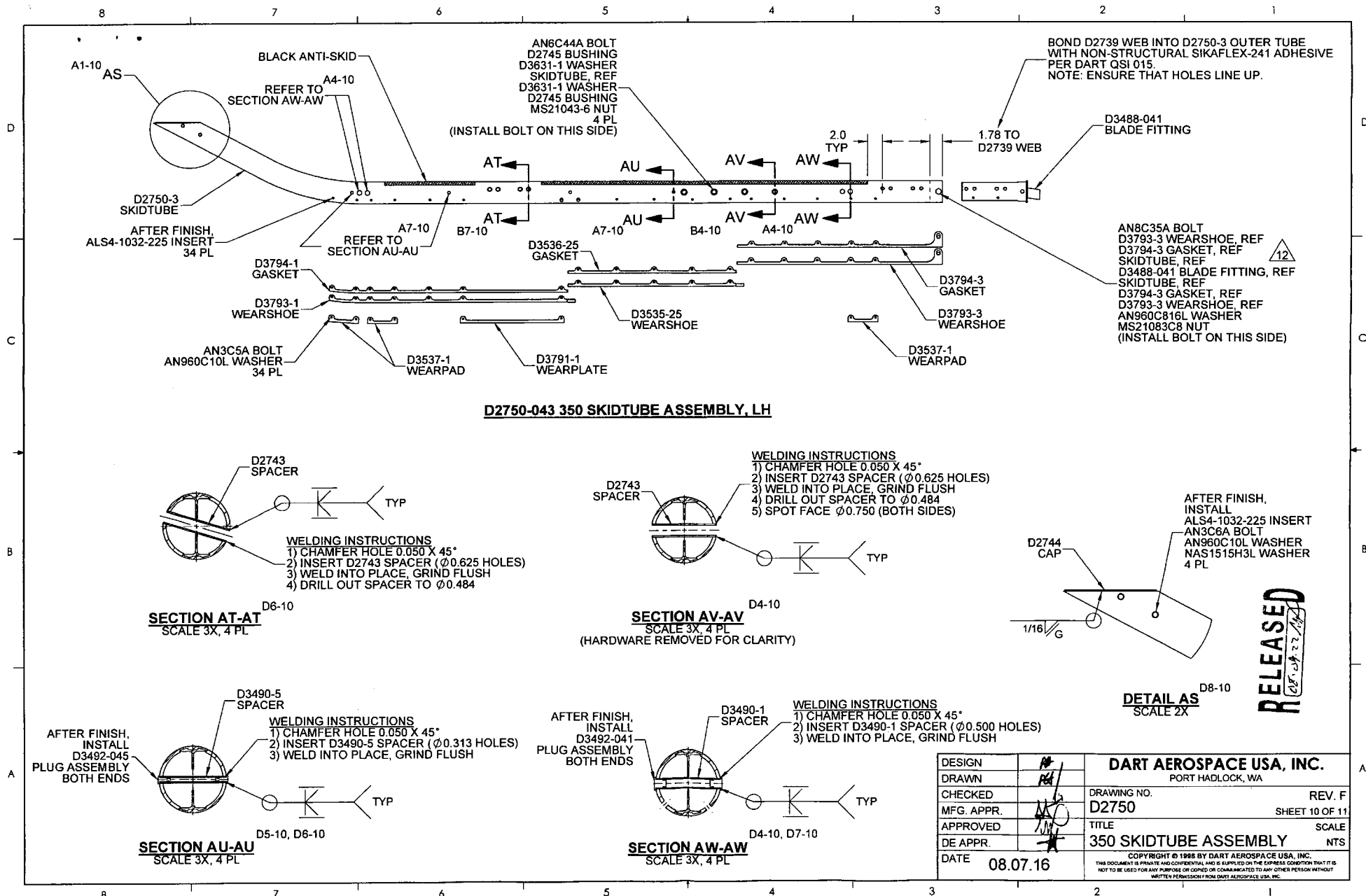
W/O 51807



W/O 51807

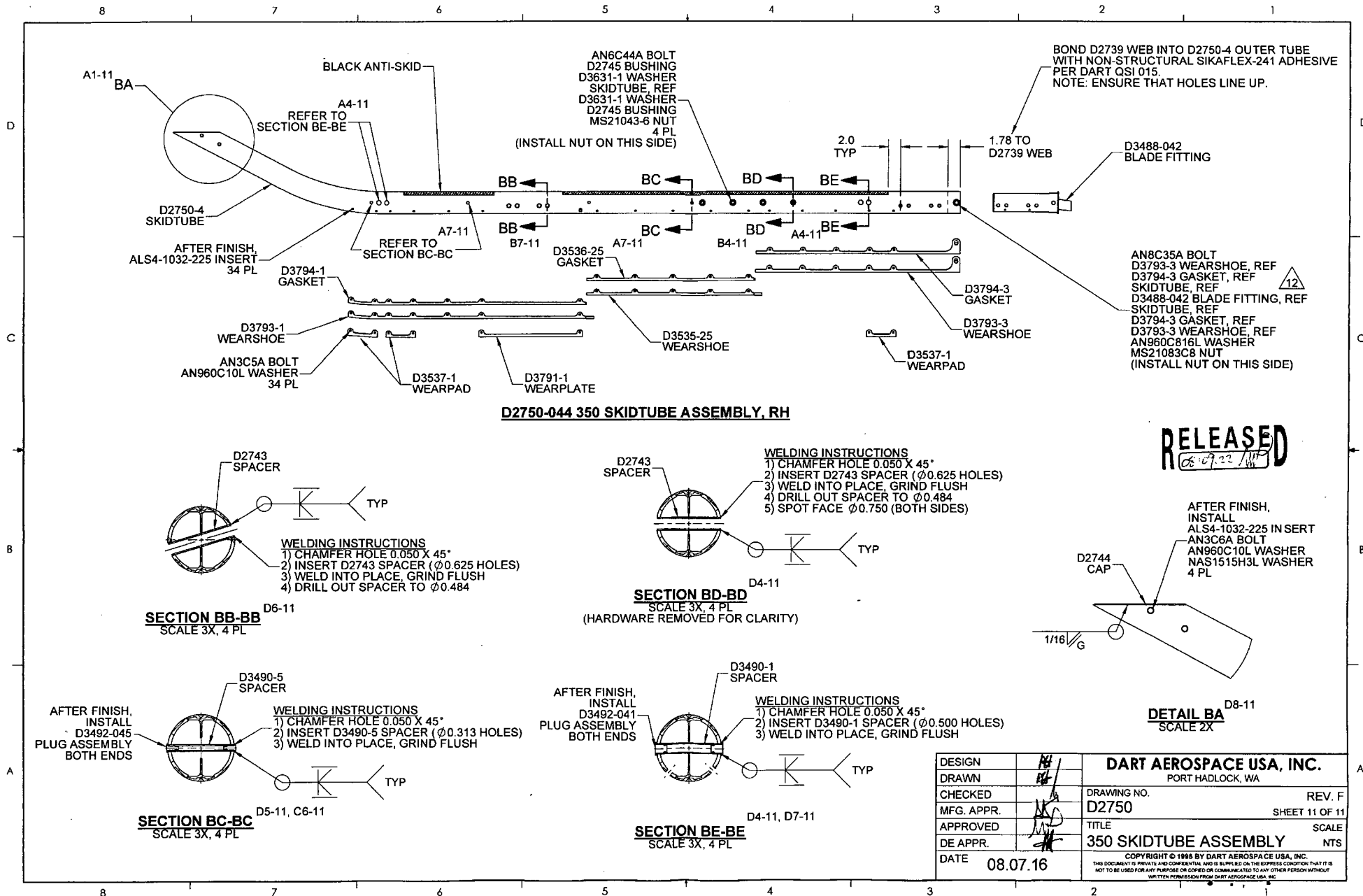


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W/O 5/807



NO. 203

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barday Elliott
Job number: 5011
Part number: D350 636 014
Description: 350 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier P. Del Date of Test Coupon 09.07.14
Welder Barday Elliott Date of Test Coupon 09.07.14

The above named individual is qualified in accordance with AWS D17.1.2001 to weld